

Work Order ID 90344

90344

Page 1

September-17-12 1:23:26 PM

Item ID: D4017-9

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib

Start Date: 9/17/12 Start Qty: 10.00

10
10 (8x)

Cust Item ID:

Required Date: 10/05/12 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12-09-18 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4017 | D |

100 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4017
2- Deburr and remove identify marks

CC 12-11-21 (8x)

110 QC6- Inspect dimensions to drawing 0.00

110

QC

Memo

0.00

Quality Control

(8) 12-11-21

DAS
09
2-89

120 Identify as per dwg & Stock Location: W/A 0.00

120

Packaging

Memo

0.00

Packaging

CC 12-11-21 (8x)

Work Order ID 90344***90344***

Page 2

September-17-12 1:23:26 PM

Item ID: D4017-9

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 9/17/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/05/12 Req'd Qty: 10.00

10

Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/11/22 
MF
12-11-21

Picklist Print

September-17-12 1:23:26 PM

Page 1

Work Order ID: 90344

Parent Item: D4017-9

Parent Item Name: Rib

Start Date: 9/17/12

Required Date: 10/05/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg RevA DD
10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP
Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 11.01.17 chg qc5 to 6 DD
verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.500W.049 Square Tubing | | Purchased | No | | | 100 | f | 1,229.0001 | 2.28166 | 24.017474 | | CC 12-11-21 | |

Location

Loc Qty

Loc Code

MAT018

643.930134

122413

643.930134

19.2139792

MAT034

585.0700153

118460

0.00001534

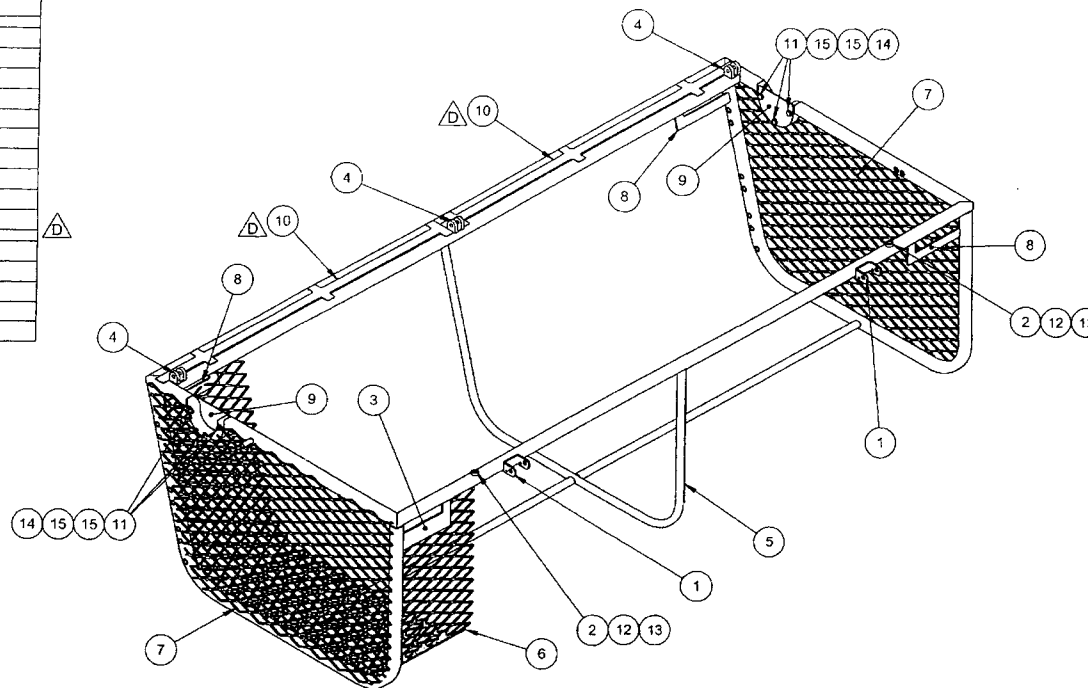
121808

0.07

122938

585

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|---------------------------------|
| | X | D4017-041 | SHORT BASKET BASE ASSY (350) |
| 1 | 2 | D2581 | MOUNTING BRACKET |
| 2 | 2 | D2931 | BUMPER |
| 3 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 4 | 3 | D4016-1 | HINGE HALF, BASE |
| 5 | 1 | D4017-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 6 | 1 | D4020-3 | MESH (350 BASKET SHORT BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 2 | D4672-3 | BLANKING PLATE |
| 11 | 6 | AN3-10A | BOLT |
| 12 | 2 | AN960JD8 | WASHER |
| 13 | 2 | MS20600AD4W3 | RIVET |
| 14 | 6 | MS21042L3 | NUT |
| 15 | 12 | NAS1149F0332P | WASHER |



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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 90344 MLG

12-09-18

D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

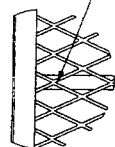
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2012-07-12
PCN 12-610

| | | | |
|------------|--|---|----------|
| D | ADD D4672-3 (ZN C5-1, D4-1, D6-1, D3-2, AND D4-2). REASON: PART 12-197. | MB | 12.06.18 |
| C | ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES. | MB | 10.07.23 |
| B | QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED, DETAIL D UPDATED (A4-3) | JPH | 10.03.25 |
| A | NEW ISSUE | AJS | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ALB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4017 REV. D SHEET 1 OF 5 TITLE SHORT BASKET BASE ASSY (350) NTS SCALE DATE 12.06.18 | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 12.06.18 | | |

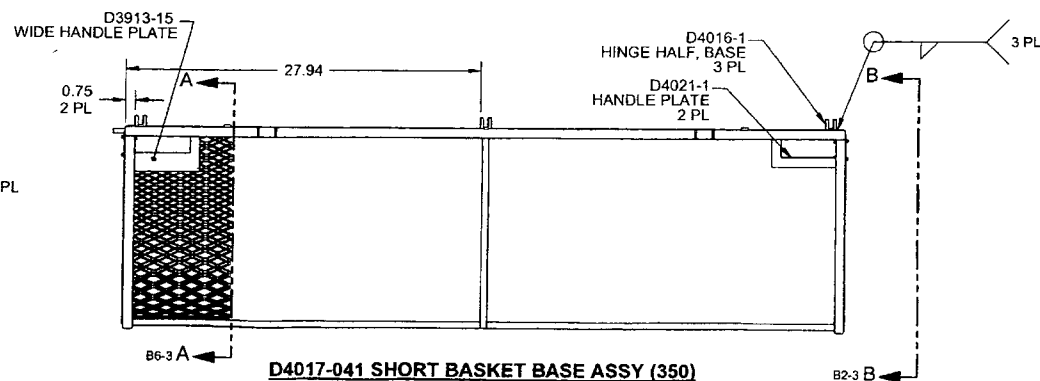
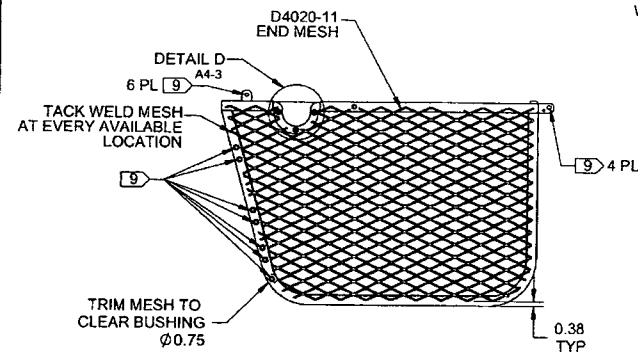
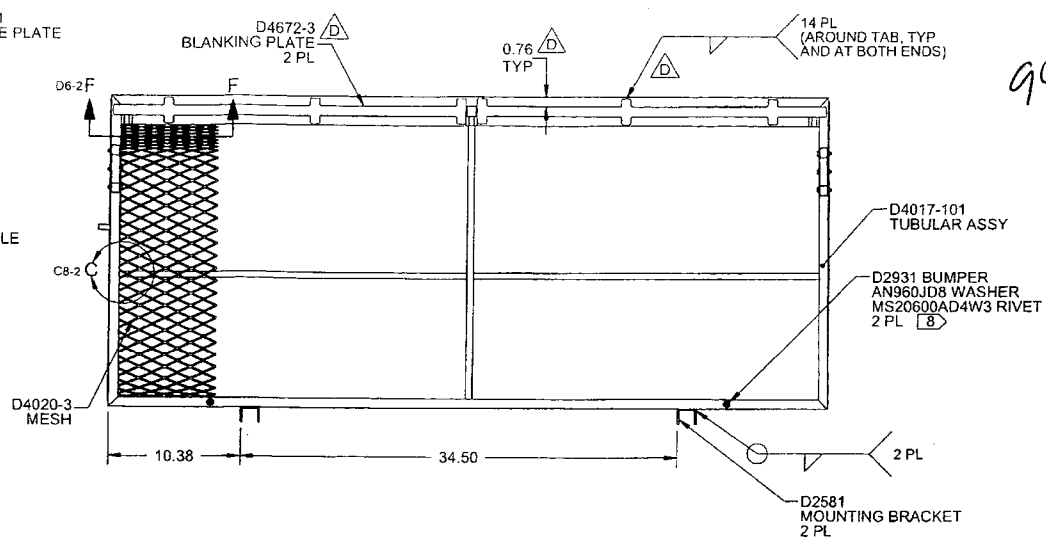
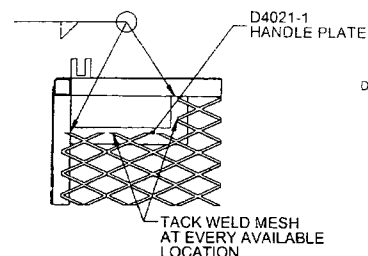
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



DETAIL C D6-2

SECTION F-F
TYPICAL FOR ALL
HANDLE PLATES

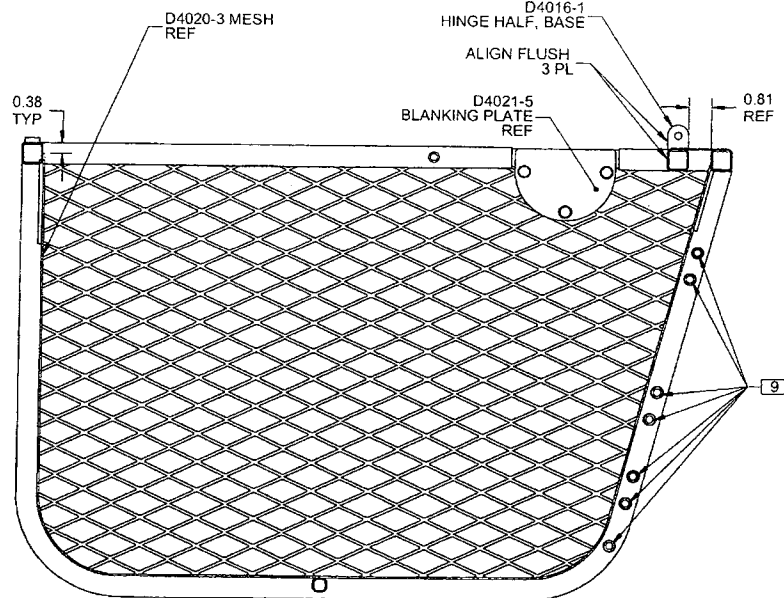


D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

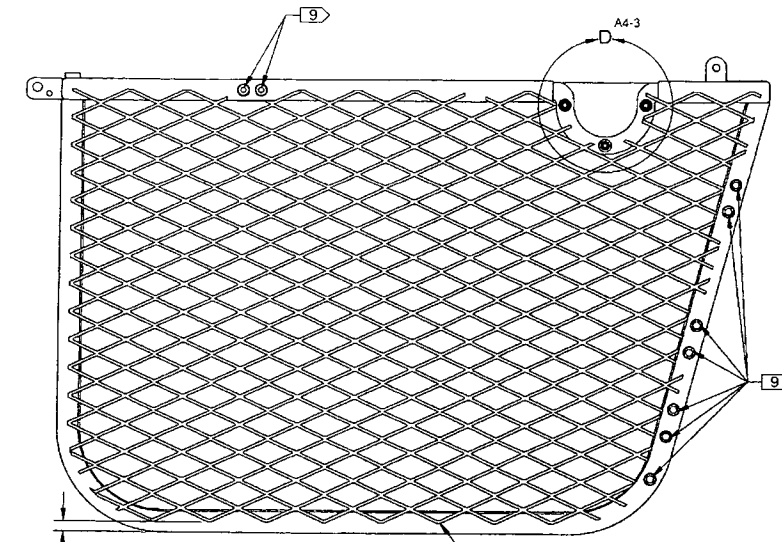
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2012-07-12
9

| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | ALS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | A.P. | DRAWING NO. D4017 | REV. D |
| MFG. APPR. | | | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SHORT BASKET BASE ASSY (350) | NTS |
| DATE | 12.06.18 | COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS RECOGNITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

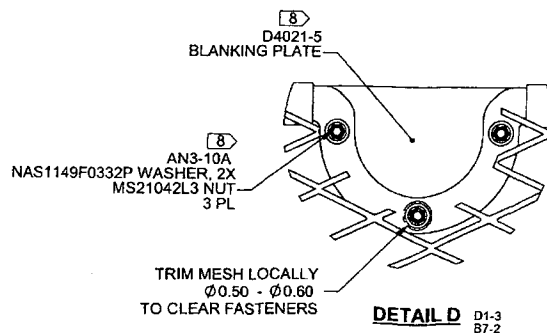
90344



SECTION A-A A5-2



SECTION B-B A2-2

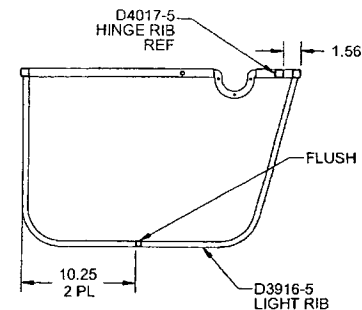
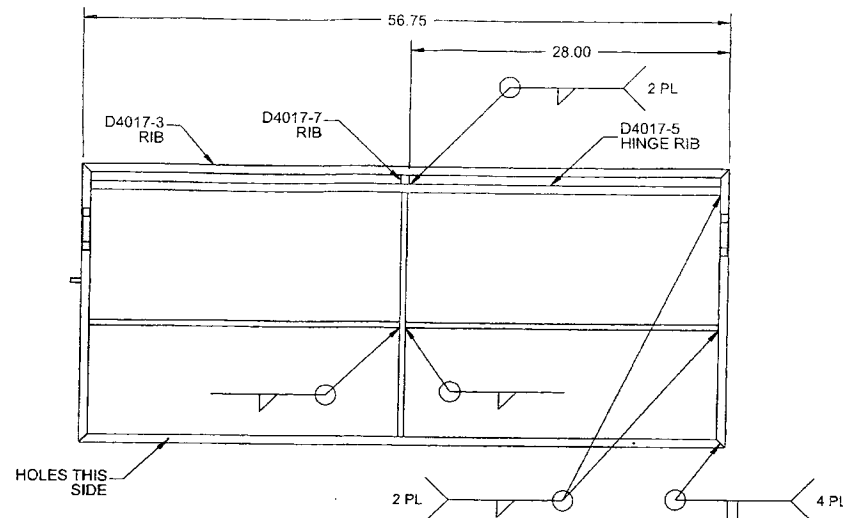


DETAIL D D1-3 87-2

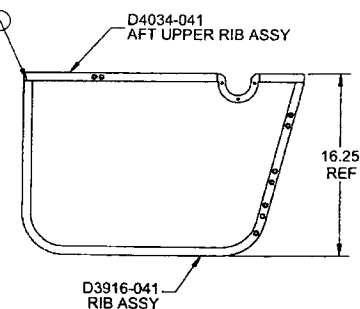
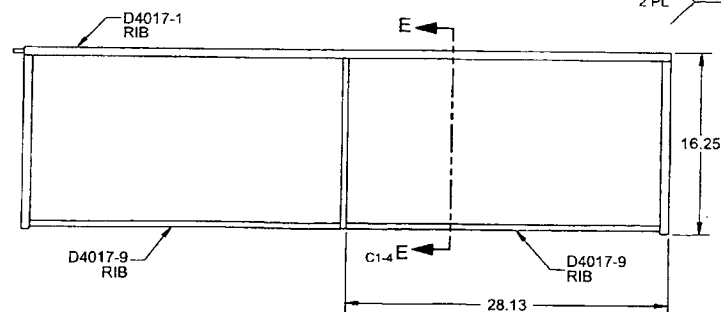
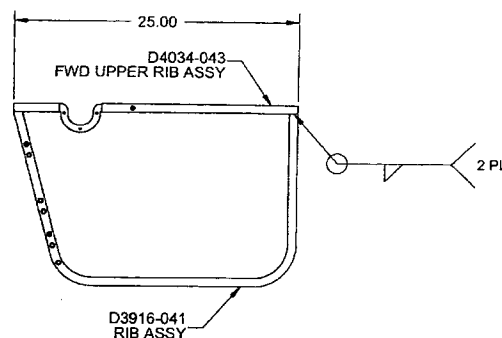
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2012-07-12
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| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | 6 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DP | DRAWING NO. | REV. D |
| MFG. APPR. | | D4017 | SHEET 3 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SHORT BASKET BASE ASSY (350) | NTS |
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| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|---------------------------------|
| | X | D4017-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 1 | 1 | D4017-1 | RIB |
| 2 | 1 | D4017-3 | RIB |
| 3 | 1 | D4017-5 | HINGE RIB |
| 4 | 1 | D4017-7 | RIB |
| 5 | 2 | D4017-9 | RIB |
| 6 | 2 | D3916-041 | RIB ASSY |
| 7 | 1 | D3916-5 | LIGHT RIB |
| 8 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 9 | 1 | D4034-043 | FWD UPPER RIB ASSY |



SECTION E-E A4-4



8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

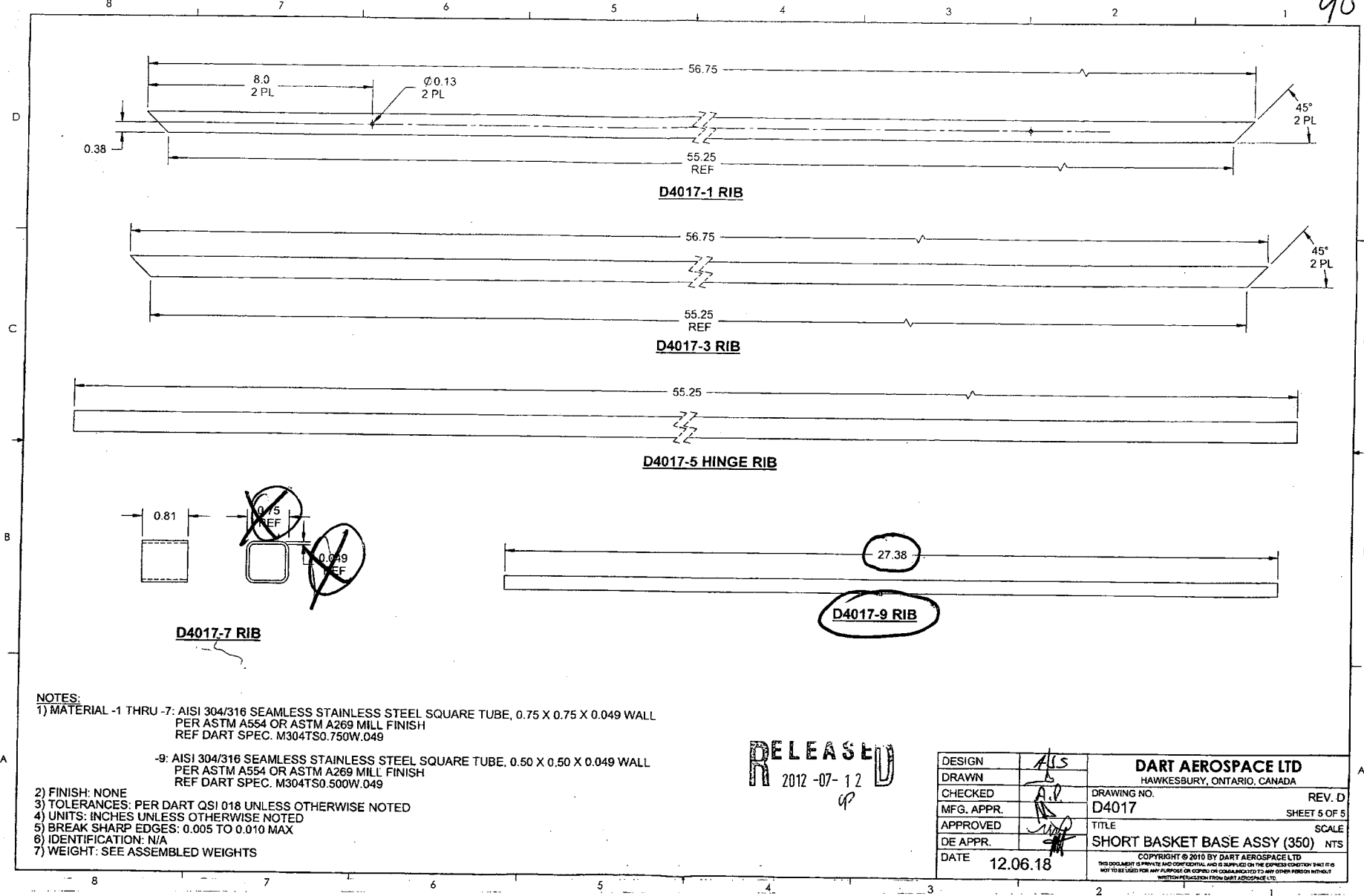
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 15.26 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
- 9) WELD PER DART QSI 004

RELEASED
2012-07-12
UP

| | | | |
|------------|----------|---|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4017 | REV. D |
| MFG. APPR. | | | SHEET 4 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SHORT BASKET BASE ASSY (350) | NTS |
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90344



NOTES:

1) MATERIAL -1 THRU -7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049

-9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS